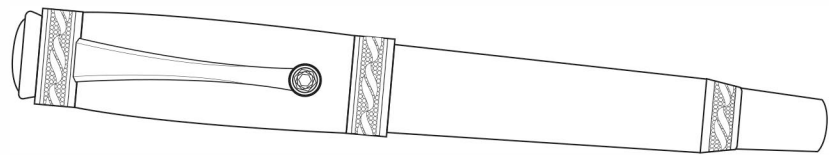


'MAJESTIC' Fountain & Roller Ball Pen Kits

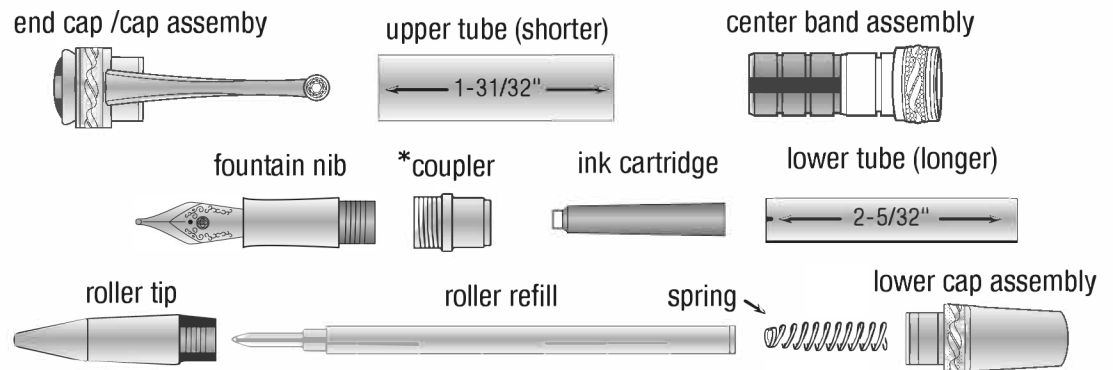
- #PKMAFTP - Fountain, Rhodium & Black TIN
- #PKMAFGP - Fountain, Rhodium & Gold
- #PKMAJTP - Roller, Rhodium & Black T/N
- #PKMAJGP - Roller, Rhodium & Gold



REQUIRED ACCESSORIES:

- 7mm Pen Mandrel
- #PKMAJBU - 3 pc. Bushing set
- #PK3764 - 37/64" Drill Bit
- #PK1532 - 15/32" Drill Bit
- #PKMAJBTS - Barrel Trimmer sleeve - 2pc set (use with 3/8" barrel trimmer)
- 2-part epoxy glue or insta-cure (cyano-acrylate) glue.

DIAGRAM A / PARTS LIST:



PREPARING THE BLANKS:

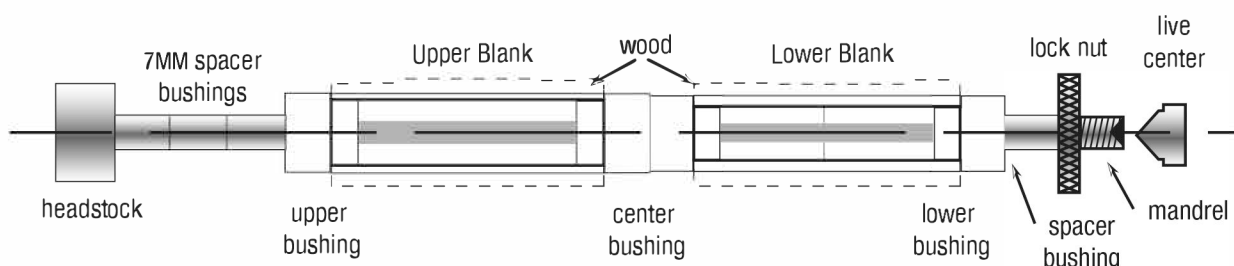
***NOTE: Check center band assembly for coupler**

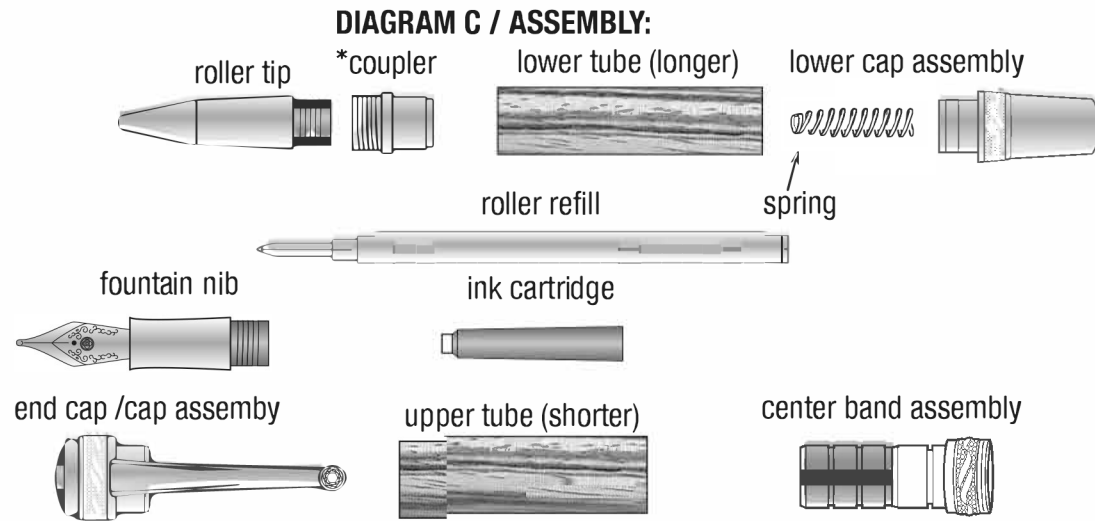
- Prepare a master blank of at least 7/8" square. Cut two sections to the length of each tube. (Add 1/16" for trimming)
- Mark the center of each blank.
 - Upper Blank - (shorter tube) - drill a 37/64" hole through the blank
 - Lower Blank - (longer tube) - drill a 15/32" hole through.
 - Glue each tube in the proper blank. Spread the glue over each tube. Insert the tube into the blank with a twisting motion to spread the glue evenly inside. Note: you may sand the tubes using 220-grit abrasive for better adhesion. Center each tube lengthwise inside the blank.
 - When glue dries; square the ends of each blank. Using a 10mm barrel trimmer with adapter sleeves, mount the proper sleeve (large diameter for the short tube, smaller diameter for the longer tube) over the shank. Trim the blank down flush with the brass tube.

TURNING THE BLANKS:

- Mount spacer bushings on the mandrel. Slide the cap bushing (wider diameter) wide end in first. Slide the upper blank (shorter) on next. Follow with the center bushing, wider diameter on first. Slide on the lower blank and follow with the tip bushing, narrow end in first. Mount spacer bushings to fill the space to the threads on the mandrel. Screw on the lock-nut hand tight. Bring the tailstock in snug to the mandrel. Lock in place. Do not over-tighten the lock nut; it may damage the mandrel.
 - Turn the blanks down close to the bushings. Follow with abrasives until the tube diameters are flush with the bushings.
- Finish with your choice of polish.

DIAGRAM B / TURNING THE BLANKS





ASSEMBLY:

***NOTE: Check center band assembly for coupler**

- NOTE: Line up the components according to Diagram 'C'. To avoid damage to components when assembling pen, use PSI #PENPRESS2.
- Press the center band assembly into the upper (shorter) tube.
- Press the end cap/clip assembly into the opposite end of the tube.
- Slide the coupler ring, smaller diameter in first over the coupler. Press the assembly in to the lower tube.
- Press the lower cap assembly (with spring inserted) into the opposite end of the tube.

ROLLER BALL

- Insert the roller refill, flat end in, into the opening at the coupler over the spring.
- Thread the roller tip over the refill into the threaded coupler.

FOUNTAIN PEN TIP

- Affix the ink reservoir, narrow end in first into the back of the pen nib. Push into break the seal (or use PSI refillable reservoirs #PKPUMP5), then press lightly the to advance the ink forward.
- Thread the fountain nib assembly over the threaded coupler.

TIPS

- When engaging the ends to close the pen, notice the threads have three starting points so you can quickly close the pen in either of three positions.
- You may also want to consider matching the wood grain when assembling the pen.

BUSHINGS

